

Date: Friday, 28/11/2008 2:54:01 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FORWARD CAP
Job Number	: 43846		
Estimate Number	: 10724		
P.O. Number	:	Part Number	: D2647
This Issue	: 28/11/2008	S.O. No.	: D2647 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: F
Previous Run	: 35475	Material	:
Written By	:	Due Date	: 20/12/2008
Checked & Approved By	: <u>JWD 08.12.01</u>	Qty:	40
Comment	: Est Rev:D 99.01.25 Re-format DM Est: E 06.11.15 waterjet EC	Um:	Each
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
			
Comment:	Qty.: 0.1677 sf(s)/Unit Total : 6.7074 sf(s) Material: 6061-T6 QQ-A-250/11 or 5052-H32 QQ-A-250/8 0.080" Thick	Batch <u>110063</u> <u>IB 8-12-15</u>	
2.0	WATER JET	FLOW WATER JET	
			
Comment:	FLOW WATER JET 1-Cut as per Dwg D2647 Dwg Rev: <u>F</u> Prog Rev: <u>F</u>	<u>IB 8-12-15</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	<u>IB 8-12-15</u>	
4.0	QC8	SECOND CHECK	
			
Comment:	SECOND CHECK	<u>S 08/12/15</u>	<u>XSD</u> <i>cauter</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment:	SMALL & MEDIUM FAB RESOURCE 1 Deburr	<u>Not Done at step 4.2</u>	
			<u>S 08/12/15</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FORWARD CAP

Job Number: 43846

Part Number: D2647

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/15 XSD

7.0 PACKAGING 1

PACKAGING RESOURCE #1



50X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: part bay

8/12/16

S/P

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/16 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/12/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43846
Description: Cap	Part Number:	D2647
Inspection Dwg: D2647	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

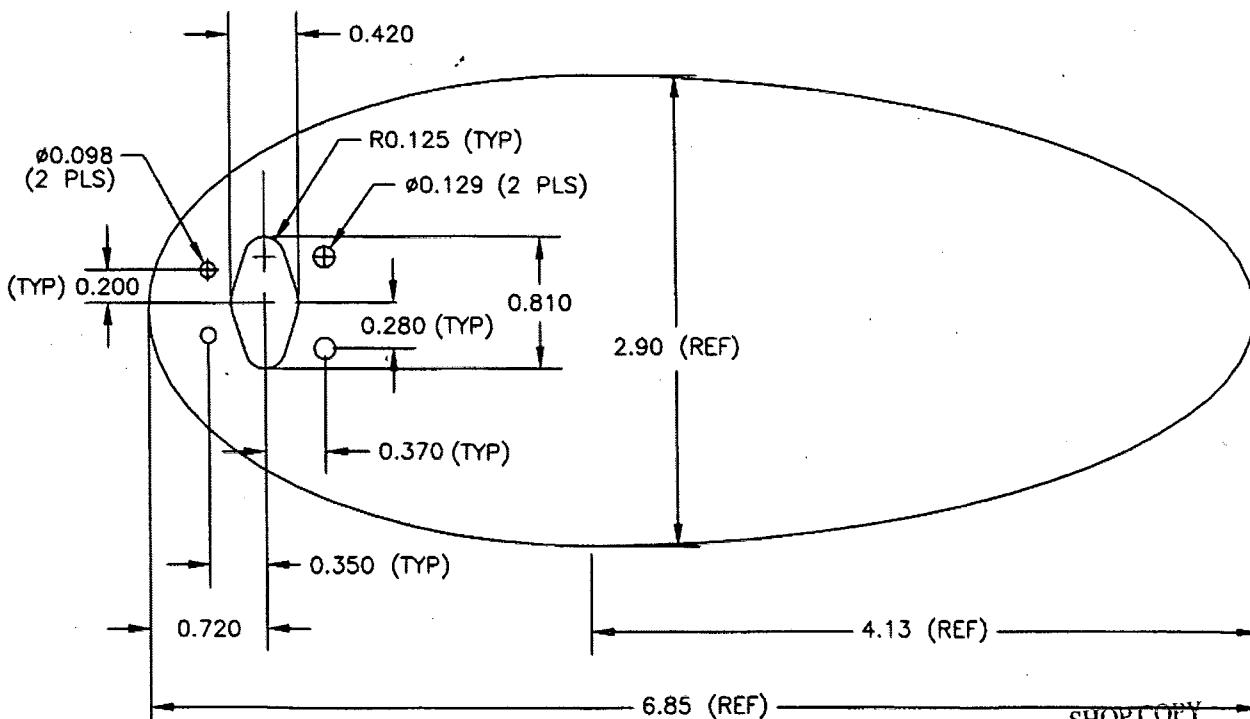
X First Article Prototype

Measured by:	<u>FB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	8-12-15	Date:	<u>08/12/15</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.26	New Issue	KJ/EC/DD	

DART

DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>RF</i>	APPROVED <i>RF</i>	DRAWING NO. D2647	REV. F SHEET 1 OF 1
DATE 00.05.26		TITLE CAP	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.27	CHANGED SHAPE	
C	97.09.15	REMOVE FRONT PLATE	
D	97.11.06	ADD RIVET HOLES	
E	98.01.15	ADD 5052 MATERIAL (TSR A245)	
F	00.05.26	MAKE FROM D2794	

RELEASED
00.06.09 RF

THIS PART CAN BE MADE FROM D2794

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45846*

MATERIAL: 6061-T6 (QQ-A-250/11) OR

5052-H32 (QQ-A-250/8) 0.080 THICK.

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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